

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)

52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
<input checked="" type="checkbox"/>	<input type="checkbox"/>	D206-802-031	PASSENGER DOOR OPENER KIT, LH
<input type="checkbox"/>	<input checked="" type="checkbox"/>	D206-802-032	PASSENGER DOOR OPENER KIT, RH

ADD:

	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
	4	CR3523-4-4	RIVET
	1	D3552-27	DOOR PROP

3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
<input checked="" type="checkbox"/>	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

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


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BY: 
D. SHEPHERD (DE # 02)

DATE: 11.12.07

CERT. NO.: SH10-44

ISSUE NO.: 1

B	ADD DOOR PROP D3552-27	AP	11.12.07
A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
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MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
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4.0 INSTALLATION CHANGE:

4.1 On metal airframe:

No change. Install D206-802-032 using D4112-1 per Section 3.3 of IIN-D206-802-3.

4.2 On composite airframe:

Install D206-802-032 by replacing D4112-1 Aft Sill Doubler with D4108-047 per instructions below and Figure 1 of this Service Instruction.

4.2.1 Perform Step 3.3.1 of IIN-D206-802-3.

4.2.2 Replace Steps 3.3.2 to 3.3.16 with the following:

- a) Using Figure 1 of this Service Instruction, locate D4108-11 Template on the edge of the door post closeout approximately 17.5" from the front of the seat. Match drill the Ø0.128" rivet holes (4 PL) on the door sill. Locate and drill thru template and door sill if the door sill is without existing holes.
- b) Transfer drill the Ø0.128" holes (4 PL) from D4108-11 Template to the D4108-047 Sill Bracket Assembly.
- c) Deburr all drilled holes and clean area.
- d) Remove and retain the Ball Stud and hardware from the D4108-047 Sill Bracket Assembly.
- e) Install D4108-047 Sill Bracket Assembly by applying a thin layer of Proseal 890 and wet installing the CR3523-4-4 Rivets (4 PL) as shown in Figure 1 of this Service Instruction.
- f) Remove excess Proseal, grind rivet stems flush and clean area of any debris.
- g) Re-install the Ball Stud and hardware removed at Step "d)" of this instruction.
- h) Re-position the carpet and interior trim panel. Trim/cut as required for the ball stud and to allow the D4108-047 Sill Bracket Assembly to protrude.
- i) Re-install the scuff plate.
- j) Install rod end of D3552-27 Door Prop onto the Ball Stud mounted on D4108-047 Sill Bracket Assembly.
- k) With the door open and using the D3552-27 Door Prop, Figure 4 and the dimensions shown as reference, position D4115-5 Doubler. Ensure that the door opens far enough for ingress and egress (minimum of 19" wide) and that there is no interference with any structure or interior trims. The final location of the D4115-5 Doubler will vary somewhat from aircraft to aircraft.

4.2.3 Perform Steps 3.3.17 to 3.3.26 of Installation Instructions IIN-D206-802-3.

4.2.4 Replace Step 3.3.27 with the following:

- a) Attach the cylinder end of the D3552-27 Door Prop to the D3622-5 Ball Stud installed on the previous step.

4.2.5 Complete installation of D206-802-032 by following Steps 3.3.28 to 3.3.29 of Installation Instructions IIN-D206-802-3.

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


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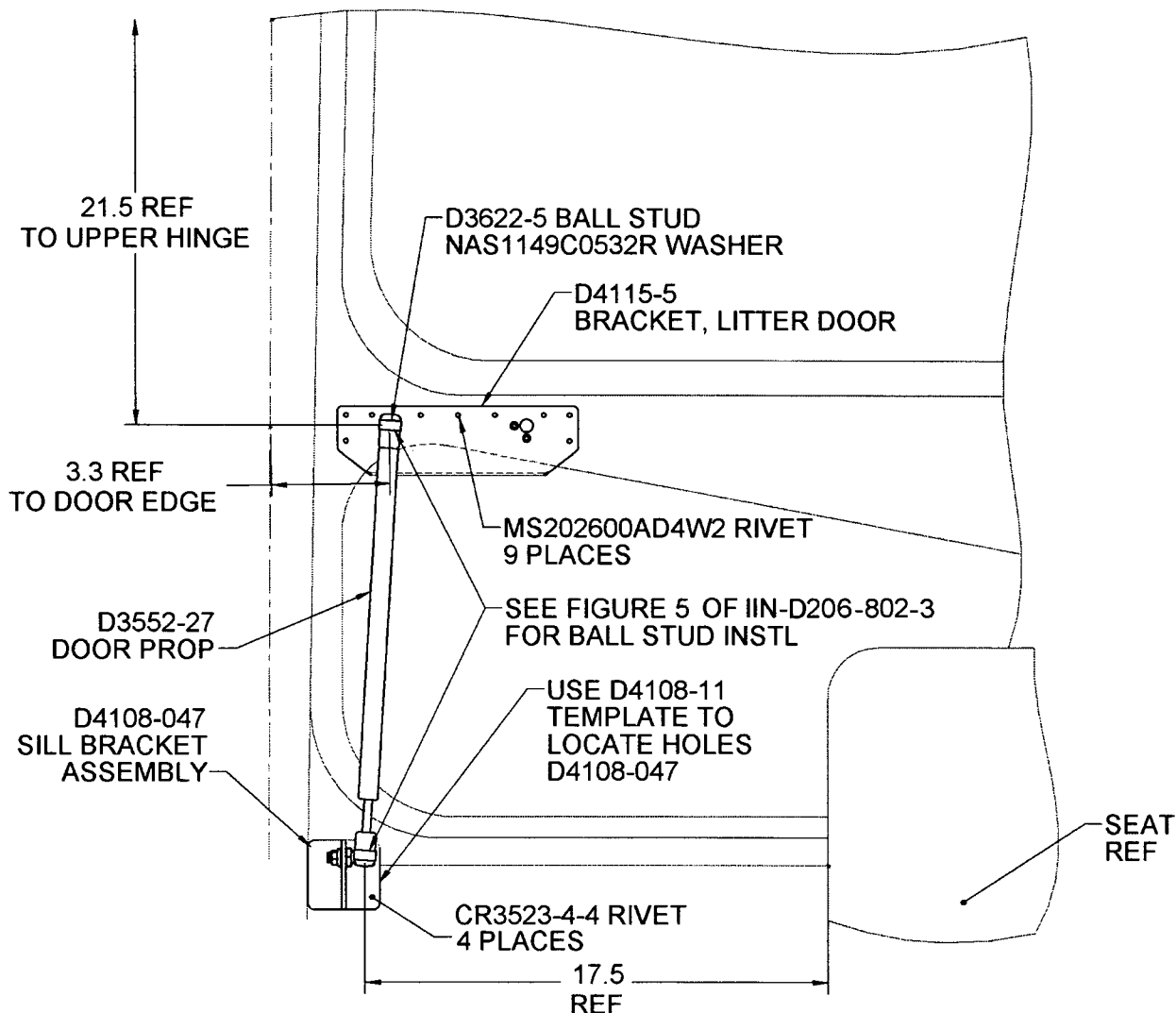


FIGURE 1: INSTALLATION OF D206-802-032 ON COMPOSITE AIRFRAME

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